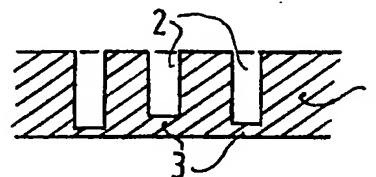


PCTWORLD INTELLECTUAL PROPERTY ORGANIZATION
International Bureau

U 015570-8

INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(51) International Patent Classification 7 : B42D 15/00		A1	(11) International Publication Number: WO 00/43216
			(43) International Publication Date: 27 July 2000 (27.07.00)
(21) International Application Number: PCT/NL00/00036			(81) Designated States: CA, CN, JP, RU, US, European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE).
(22) International Filing Date: 18 January 2000 (18.01.00)			
(30) Priority Data:			
1011103 21 January 1999 (21.01.99) NL			
1012460 28 June 1999 (28.06.99) NL			
(71) Applicants (for all designated States except US): INDUSTRIAL AUTOMATION INTEGRATORS (IAI) B.V. [NL/NL]; De Run 6509, NL-5504 DR Veldhoven (NL). ENSCHEDE/SDU B.V. [NL/NL]; Jan van Krimpenweg 19, NL-2031 CG Haarlem (NL).			Published <i>With international search report.</i> <i>Before the expiration of the time limit for amending the claims and to be republished in the event of the receipt of amendments.</i> <i>In English translation (filed in Dutch).</i>
(72) Inventors; and			
(75) Inventors/Applicants (for US only): COBBEN, Johannes, Ignatius, Marie [NL/NL]; Berthastraat 11, NL-5507 LT Veldhoven (NL). AUGUSTINUS, Arnoud [NL/NL]; Heilige Geeststraat 2, NL-5521 LC Eersel (NL). VAN DEN BERG, Jan [NL/NL]; Bloklandpolderstraat 15, NL-2807 LH Gouda (NL).			
(74) Agent: EVELEENS MAARSE, Pieter, Arnold & Siedsma, Sweelinckplein 1, NL-2517 GK The Hague (NL).			
(54) Title: SECURITY DOCUMENT WITH A PERFORATION PATTERN			
(57) Abstract			
<p>The invention relates to a forge-proof document comprising a security feature in the form of a perforation pattern which displays grey tones when viewed against a bright background, wherein the document is manufactured from a material which transmits light to a limited extent, at least some of the perforations forming part of the perforation pattern extend over only a part of the thickness of the document at the position of the perforation, and the thickness of the remaining part of the document at the position of the perforation is modulated in accordance with the image to be displayed. The invention also relates to such a document comprising a security feature in the form of a perforation pattern which displays grey tones when viewed against a bright background, wherein at least some of the perforations forming part of the perforation pattern extend at an angle differing from 90° relative to the main plane of the document.</p>			



FOR THE PURPOSES OF INFORMATION ONLY

Codes used to identify States party to the PCT on the front pages of pamphlets publishing international applications under the PCT.

AL	Albania	ES	Spain	LS	Lesotho	SI	Slovenia
AM	Armenia	FI	Finland	LT	Lithuania	SK	Slovakia
AT	Austria	FR	France	LU	Luxembourg	SN	Senegal
AU	Australia	GA	Gabon	LV	Latvia	SZ	Swaziland
AZ	Azerbaijan	GB	United Kingdom	MC	Monaco	TD	Chad
BA	Bosnia and Herzegovina	GE	Georgia	MD	Republic of Moldova	TG	Togo
BB	Barbados	GH	Ghana	MG	Madagascar	TJ	Tajikistan
BE	Belgium	GN	Guinea	MK	The former Yugoslav Republic of Macedonia	TM	Turkmenistan
BF	Burkina Faso	GR	Greece	ML	Mali	TR	Turkey
BG	Bulgaria	HU	Hungary	MN	Mongolia	TT	Trinidad and Tobago
BJ	Benin	IE	Ireland	MR	Mauritania	UA	Ukraine
BR	Brazil	IL	Israel	MW	Malawi	UG	Uganda
BY	Belarus	IS	Iceland	MX	Mexico	US	United States of America
CA	Canada	IT	Italy	NE	Niger	UZ	Uzbekistan
CF	Central African Republic	JP	Japan	NL	Netherlands	VN	Viet Nam
CG	Congo	KE	Kenya	NO	Norway	YU	Yugoslavia
CH	Switzerland	KG	Kyrgyzstan	NZ	New Zealand	ZW	Zimbabwe
CI	Côte d'Ivoire	KP	Democratic People's Republic of Korea	PL	Poland		
CM	Cameroon	KR	Republic of Korea	PT	Portugal		
CN	China	KZ	Kazakhstan	RO	Romania		
CU	Cuba	LC	Saint Lucia	RU	Russian Federation		
CZ	Czech Republic	LI	Liechtenstein	SD	Sudan		
DE	Germany	LK	Sri Lanka	SE	Sweden		
DK	Denmark	LR	Liberia	SG	Singapore		
EE	Estonia						

SECURITY DOCUMENT WITH A PERFORATION PATTERN

5

The present invention relates to a forge-proof document comprising a security feature in the form of a perforation pattern which displays grey tones when viewed against a bright background.

10

Such a document is known from WO98/19869.

Although the prior art document in question provides a very good security against forgery, it is important to develop new security features in respect of the technical potential of forgers.

15

For this purpose the present invention provides the measure that the document is manufactured from a material which transmits light to a limited extent, that the perforation extends over only a part of the thickness of the document at the position of the perforation, and that the thickness of the remaining part of the document at the position of the perforation is modulated in accordance with the image to be displayed.

This measure results in a further degree of difficulty; the determining factor for displaying the grey tone of the perforation, and therewith the image, is determined by the remaining thickness of the document. This means that the depth of the non-continuous perforation must be determined very precisely. The resulting thickness is after all the difference between two larger values, i.e. the thickness of the total document and the depth of the perforation.

According to another independent measure according to the invention, the perforation extends at an angle differing from 90° relative to the main plane of the document. This has the result that the perforation cannot be arranged with very small drills, but that use will have to be made of a laser, which on the one hand

35

requires a large investment and on the other requires a high degree of technical knowledge.

This method of arranging provides the option of modulating the angle so as to obtain a grey-value modulation.

There is moreover the possibility, as in the classic straight perforations, of modulating the density of the perforation or the size, i.e. the diameter, thereof.

10 The perforation is preferably an image.

It is herein noted that the image as arranged by means of perforation can be subjected to a certain degree of image-processing. It is hereby possible to compensate the features of the image lost due to the necessary quantization. An example of such an image-processing is "contour enhancement".

The invention is also applicable to perforation patterns which do not represent an image, but which represent an alphanumeric expression or a code.

20 It will be apparent that a combination of these possibilities can be applied. Such an oblique perforation can of course be combined with a normal straight perforation. This combination provides the option of introducing an extra pattern. The main image, which is modulated in order to display grey tones, is for instance arranged herein with a straight perforation, while an additional feature, for instance in the form of a logo or letters, is arranged obliquely. The choice of the angle or other properties of the oblique perforation can be
30 chosen such that during normal observation of the pattern at an angle of about 90° the normal image appears, and that during observation at another angle the second image in the form of a logo or a letter combination becomes visible.

35 Another example is the arranging of two images at the same position on the carrier, although at different angles such that each eye sees its own image, and a stereo image is thus observed.

It will be apparent that this can be varied in numerous ways.

It is attractive herein to make use of a method wherein the document to be protected is irradiated by a laser source from two positions. It is of course possible herein to make use of two laser sources, although it is of course simpler to first irradiate the document in a first position with a laser source at a first angle and to then place the document in a different position wherein it is irradiated by the same laser source at a different angle.

When the laser source is placed close to document, it is also possible to arrange a perforation at an angle differing from 90° ; this is caused by the cone or pyramid shape inside which the laser light beam must displace in order to arrange the perforation. A pattern then results which has an increasing angle as the distance to the centre of the image increases.

According to another preferred embodiment of the invention the cross-section of the perforation in its transverse plane is unequal to a circle. The use of a laser source provides the possibility of performing such a perforation when there is a correct control of the positions of the laser spot. It is in any case practically impossible to obtain this with mechanical means in view of the fineness of the required pattern.

According to another preferred embodiment a code is concealed in the representation of the image. Use can be made herein of the teachings already applied in graphic techniques, according to which it is possible to arrange changes in an image which are not visible to the normal eye and which result after a specific processing in a code being displayed.

Conversely, an immediately visible coding can also be chosen. The code can be used for instance to identify the machine on which the relevant product was made. The relevant machine can thus be identified in the case of improper use of a machine.

According to yet another embodiment an intermediate layer is arranged in the document, which layer is provided with an ink.

The use of laser provides the possibility of complete removal, i.e. burning, evaporating and so on, of the material from which the document is manufactured. Contamination of the relevant layers of the document will herein hardly occur. When such a document is processed with mechanical means, a degree of smearing will occur.

10 This smearing can be observed particularly well when the ink is formed by ink sensitive in UV light.

According to another embodiment, perforations arranged in a carrier in a pattern representing an image are filled with an ink which lights up under UV light.
15 Such a pattern becomes visible if it is illuminated with a UV light source.

In another embodiment the inner sides of the perforations of such a pattern are provided with a layer, for instance by vapour-deposition of a reflecting metal layer, resulting in an image which is visible when
20 viewed. Selective application of a layer to the inner side of all perforations is possible by arranging a removable foil before the perforations are arranged and removing it after said layer has been applied.

25 In another embodiment the starting point is a carrier which is built up of material layers of different colours. By modulating the depth the perforation can be made to end in the desired layer and thereby make a desired colour visible. An image in colour can thus be
30 realized.

The invention further provides the option of arranging the perforation in a protected element mounted on the carrier, such as an optically variable element such as a hologram or a kinegram. Such security features
35 are not accessible to a forger, since they are only transacted between one manufacturer and one buyer. By furthermore providing such a security feature with a personalized perforation pattern, the forger is also

deprived of the possibility of transferring such an element from one document to another.

When the image represented by the perforation pattern corresponds with another image arranged on the document, it is possible to have the images coincide. This provides the option of having both images coincide precisely. This has as advantages: the problems for the forger and counterfeiter increase, verification becomes even faster and simpler, and no extra surface area is required for the perforated image.

The present invention will be elucidated hereinbelow with reference to the annexed drawings, in which:

figure 1 shows a cross-sectional view of a first embodiment of a document according to the present invention;

figure 2 shows a cross-sectional view of a second embodiment of a document according to the present invention;

figure 3 shows a cross-sectional view of a third embodiment of a document according to the present invention;

figure 4 is a cross-sectional view of a fourth embodiment of a document according to the present invention;

figure 5 is a cross-sectional view of a fifth embodiment of a document according to the present invention;

figure 6 shows a schematic perspective detail view of a sixth embodiment of the invention;

figure 7 is a schematic perspective detail view of a seventh embodiment of the invention;

figure 8 is a cross-sectional view of an eighth embodiment of the invention, which also serves to elucidate the method used therein; and

figure 9 shows a cross-sectional view of a ninth embodiment of the present invention.

Figure 1 shows a cross-section of a document 1. Document 1 is manufactured from plastic but can likewise be manufactured from another material, such as paper, textile, and it can also be manufactured from laminated material, wherein a combination of diverse material types is made.

As elucidated in the international patent application with publication number WO98/19869, such a document is provided with perforations. In figure 1 the perforations 2 have been arranged. In this first embodiment of the present invention perforations 2 do not extend through the whole thickness of document 1 but leave a part 3 of the document intact.

The remaining parts 3 of the diverse perforations are herein of differing thickness. They therefore transmit light to a greater or lesser extent and, when the document is held against the light, an image comprising grey tones will result subject to the thickness of the remaining part 3 and the depth of perforation 2.

According to an embodiment as shown in figure 2, the perforations are arranged obliquely, i.e. at an angle differing from 90° relative to the main plane of the document. It is herein possible to obtain a modulation of the grey tones by varying the relevant angle. This is elucidated with dotted lines in figure 2.

It is further possible as shown in figure 3 to modulate the width, i.e. the diameter of holes 4. It is of course possible here to combine both forms of modulation. It is moreover possible to combine one of the two modulation forms or both of them with modulation of the density of the perforations.

It is of course possible to assign determined properties to such a combination of modulation methods. An example hereof is shown in figure 4.

When the document is viewed straight on, as indicated with dotted lines in figure 3, a similar grey tone is herein displayed for each of the perforations.

This grey tone can be modulated by varying the density or by varying the size of the perforations. It is herein possible according to the invention to generate an image.

Owing to the fact that both perforations 4 are arranged obliquely, it is possible to provide these perforations with extra information, for instance by arranging them in the form of a letter or a logo. This is of course only visible when the image is viewed at a determined angle.

10 In the embodiment shown in figure 5 a perforation in the form of a cone or in the form of a truncated cone is obtained in both cases. Modulation of the visible grey tone can herein be obtained by varying the "depth" of the cone or its apex angle. This thus
15 forms a combination of depth of hole modulation and diameter of hole modulation. Perforation 10 is thus for instance continuous, while perforation 11 is blind.

It is further possible, as shown in figure 6, to arrange a perforation in a form differing from a
20 circle, for instance a rectangle 6. The rectangular perforation can be difficult to obtain with mechanical means, so that a laser is necessary for this purpose. A laser beam can after all be controlled such that it causes a perforation with such a contour, provided the
25 focussing is sufficiently fine. It will be apparent that other shapes are possible, such as triangles, squares, ovals and so on.

Figure 7 shows a configuration wherein this document is provided with layer 7 provided with ink. This
30 layer is not particularly noticeable when the perforation is arranged with a laser; this layer is also removed by the laser. When an attempt is made to provide such a document with a perforation by means of mechanical means, for instance drilling, the ink will smear, which is
35 clearly visible.

Such a configuration can also be applied to laminated cards, the inner layer of which has a colour,

for instance white, which differs from the colours of the other layers.

Figure 8 shows how it is possible, using the same laser light source 8, to provide the same document 1 in different positions with a straight perforation 5 and subsequently with an oblique perforation 4. It is of course essential herein that the laser light beam 9 leaving laser source 8 can be deflected sufficiently. In addition, accurate stops and the like are necessary for the required precision in the positioning of document 2 in the different positions. It will be apparent that it is possible to perforate the document from more than two positions.

Finally, figure 9 shows an embodiment wherein laser light source 8 is placed relatively close to document 1, so that as a result of the angular deviation there result perforations which extend at a different angle. It will further be apparent that it is possible within the scope of the present invention to vary in countless ways from the shown embodiments.

CLAIMS

1. Forge-proof document comprising a security
5 feature in the form of a perforation pattern which
displays grey tones when viewed against a bright
background, **characterized in that** the document is
manufactured from a material which transmits light to a
limited extent, that at least some of the perforations
10 forming part of the perforation pattern extend over only
a part of the thickness of the document at the position
of the perforation, and that the thickness of the
remaining part of the document at the position of the
perforation is modulated in accordance with the image to
15 be displayed.

2. Forge-proof document comprising a security
feature in the form of a perforation pattern which
displays grey tones when viewed against a bright
background, **characterized in that** at least some of the
20 perforations forming part of the perforation pattern
extend at an angle differing from 90° relative to the
main plane of the document.

3. Document as claimed in claim 2,
characterized in that the angle is modulated in order to
25 obtain the image.

4. Document as claimed in claim 2 or 3,
characterized in that the density or the diameter of the
perforation is modulated in order to obtain the image.

5. Document as claimed in any of the foregoing
30 claims, **characterized in that** the perforation represents
an image.

6. Forge-proof document comprising a security
feature in the form of a perforation pattern which
represents an image and which displays grey tones when
35 viewed against a bright background, **characterized in that**
material is arranged in the perforations.

7. Document as claimed in claim 6,
characterized in that the material is formed by ink which
lights up under UV light.

8. Document as claimed in claim 6,
5 **characterized in that** a vapour-deposited metal layer is
arranged in the perforations.

9. Document as claimed in any of the foregoing
claims, **characterized in that** the document comprises
differently coloured material layers, wherein a colour is
10 visible depending on the depth of the perforation.

10. Document as claimed in claim 9,
characterized in that the document is manufactured from
plastic laminate and that the core layer has a colour
differing from the other layers.

15 11. Document as claimed in any of the foregoing
claims, **characterized in that** the perforation pattern is
further provided with perforations modulated in density
or size.

12. Document as claimed in any of the foregoing
20 claims, **characterized in that** the perforation pattern is
provided locally with a perforation pattern differing
from the rest of the perforation pattern.

13. Document as claimed in claim 3, 4, 5, 6 or
7, **characterized in that** the perforation pattern is
25 adapted to present a stereo image to the observer from a
viewing position.

14. Document as claimed in claim 3, 4, 5, 6 or
7, **characterized in that** the perforation pattern is
adapted to present to the user an image which differs per
30 angle of view.

15. Document as claimed in claim 14,
characterized in that the angle of the perforations to
the main plane of the document increase as the distance
to the centre of the perforation pattern increases.

35 16. Document as claimed in any of the foregoing
claims, **characterized in that** the cross-section of the
perforation pattern in its transverse plane is unequal to
a circle.

17. Document as claimed in any of the foregoing claims, **characterized in that** a code is concealed in the representation of an image.

18. Document as claimed in any of the foregoing
5 claims, **characterized in that** an intermediate layer with an ink is arranged in the carrier.

19. Document as claimed in claim 18,
characterized in that the ink is only visible ink in UV light.

10 20. Document as claimed in any of the foregoing claims, **characterized in that** the perforation is arranged in a protected element mounted on the carrier, such as an optically variable element.

21. Document as claimed in any of the foregoing
15 claims, wherein the image represented by the perforation pattern corresponds with an image applied by means of graphic techniques, laser engraving technique or a photo, **characterized in that** both images coincide.

22. Document as claimed in claim 21,
20 **characterized in that** the images are personalized.

23. Method for arranging a perforation pattern in a document as claimed in claim 3 or any of the claims dependent on claim 3, wherein the perforations are arranged by a laser, **characterized in that** the document
25 is processed in at least two different positions by a laser source.

24. Method for arranging a perforation pattern in a document as claimed in claim 16, **characterized in that** the document is processed in a single position from
30 a single laser source.

25. Method for arranging a perforation pattern in a document as claimed in claim 9, **characterized in that** a layer is first arranged on the document, the perforation is subsequently arranged, the document is
35 then subjected to a vapour deposition process and finally the foil is removed.

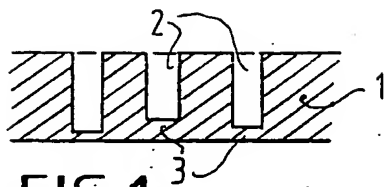


FIG. 1

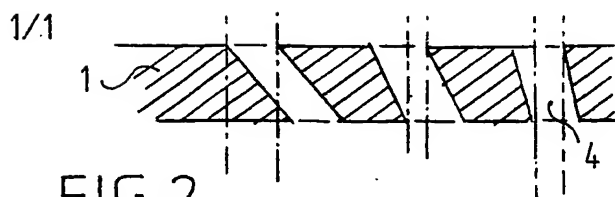


FIG. 2

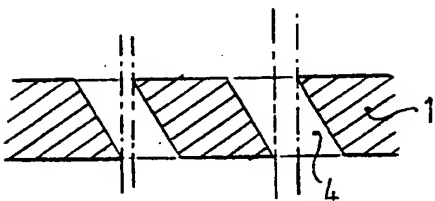


FIG. 3

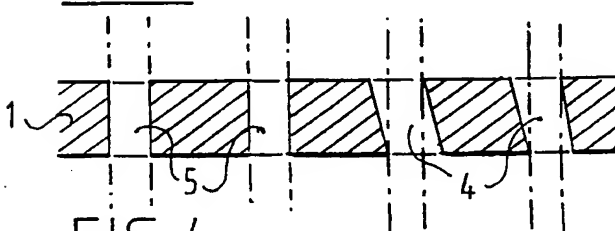


FIG. 4



FIG. 5

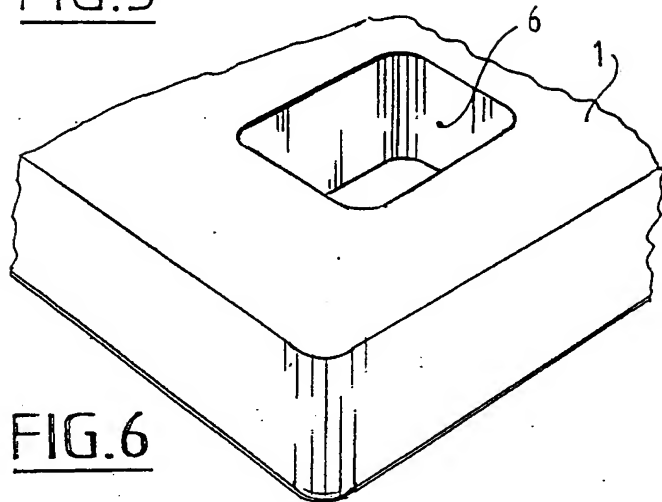


FIG. 6

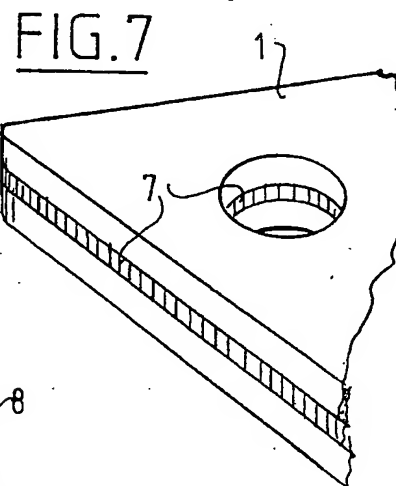


FIG. 7

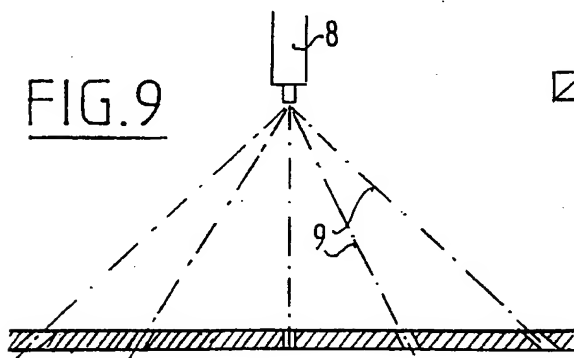


FIG. 9

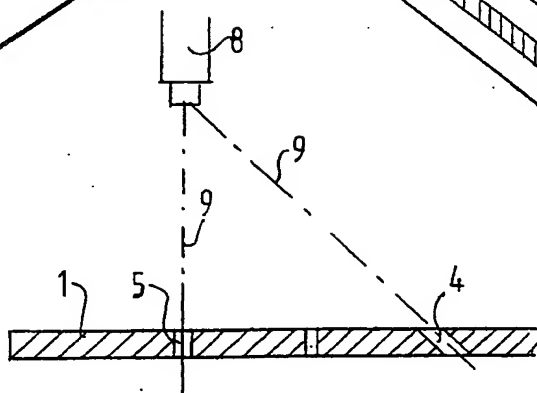


FIG. 8

INTERNATIONAL SEARCH REPORT

Intel. Application No.

PCT/NL 00/00036

A. CLASSIFICATION OF SUBJECT MATTER
IPC 7 B42D15/00

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 7 B42D

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	WO 98 19869 A (INDUSTRIAL AUTOMATION INTEGRATORS) 14 May 1998 (1998-05-14) cited in the application the whole document	1,2,6,23

☐ Further documents are listed in the continuation of box C.☒ Patent family members are listed in annex.

* Special categories of cited documents:

"A" document defining the general state of the art which is not considered to be of particular relevance

"E" earlier document but published on or after the international filing date

"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)

"O" document referring to an oral disclosure, use, exhibition or other means

"P" document published prior to the international filing date but later than the priority date claimed

"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.

"A" document member of the same patent family

Date of the actual completion of the international search

8 May 2000

Date of mailing of the international search report

15/05/2000

Name and mailing address of the ISA

European Patent Office, P.B. 5818 Patentlaan 2
NL - 2280 HV Rijswijk
Tel. (+31-70) 340-2040, Tx. 31 651 epo nl,
Fax: (+31-70) 340-3016

Authorized officer

Evans, A

INTERNATIONAL SEARCH REPORT

information on patent family members

Inter application No

PCT/NL 00/00036

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
WO 9819869 A	14-05-1998	NL 1004433 C	08-05-1998
		CN 1236345 A	24-11-1999
		EP 0936975 A	25-08-1999